

5/19

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23076</b>
<b>Description:</b> Bearpaw Kit (13" x 16")	<b>Part Number:</b>	<b>K10005</b>
<b>Dwg:</b> D2671 Rev. B1	<b>Qty:</b>	<b>5 Kits</b>
<b>Ref:</b> K10005 Rev. A; DSK086-1 Rev. A		<b>Page 1 of 1</b>

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler <b>Note: (1) K10005 Kit consists of Qty (2) D2671</b> <b>Dwg not required</b>	HA	05.04.19	5																																																
2	DC	Photocopy bluefile: K10005 D206-559-021 D500-572-021 and create labels per PPP K10005 CHG002 <b>(Bag Bluefiles separately)</b>	nk 17 dy DA	05.04.27	5																																																
3	GA	<b>Cut 2 blanks per (1) K10005 Kit</b> Cut blank: 13.25" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-1 Material: Black UHMW 1" (MUHMWB10) Batch: <u>B17726</u>	ME	05/06/02	5																																																
4	MV	Inspect material for defects or damage prior to machining	ME	05/06/02	5																																																
5	MV	Machine as per Folio and Dwg D2671 <b>Identify as D2671</b>	SD Folio Rev B1	05/06/03	5																																																
6	QC2	Inspect parts as they come off the CNC machine	SD/ME	05/06/03	5																																																
7	MV	Deburr	SD/ME	05/06/03	5																																																
8	QC8 & 5	Second inspection	SD	05.06.04	5																																																
9	KP	<b>Pick: Packing Kit (Note: D2671 is on the BOM as material from step 3)</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B21872</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B22494</td></tr><tr><td>2</td><td>D2671</td><td>Bearpaw</td><td>B23076</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B22503</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B22504</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>M16067</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>M14526</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M16941</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15924</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td>M116020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber Cushion	B21872	8	D2274	Radius Block	B22494	2	D2671	Bearpaw	B23076	4	D2438	Clamp	B22503	8	D2529	Washer	B22504	8	AN4-15A	Bolt	M16067	8	AN4-17A	Bolt	M14526	16	AN960JD416	Washer	M16941	8	MS21042L4	Nut (or -4)	M15924	2	QS200M44S	Clamp	M116020	1	Paperwork package from Step 2			CL	05/06/07	5
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10	QC4	Inspect Kit for 100% Completeness on the W/O	SD	05/06/07	5																																																
11	PK	Identify and pack for shipping as per PPP K10005 <b>REC.C</b>	CL	05/06/09	5																																																
12	AC	Cost / part <u>155.53</u>	HA	05/06/13	5																																																
13	DC	Close W/O <u>160.50</u> Inspect Level 21	HA	05.06.14	5																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10005 created for Bearpaw Kit	EC	
B	03.05.28	Reformat; Incorporated D2671	KJ/RF	
C	04.02.17	Blank size changed	KJ/JLM	

AP  
05/06/10RELEASED  
04.02.2010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	23076
Description: Bearpaw		Part Number:	D2671
Inspection Dwg: D2671	Rev: B1	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053 x 45°	✓		Vern	
B	5.500	+/-0.030	5.502	✓		Vern	
C	0.200	+/-0.030	0.209	✓		Vern	
D	R0.250	+/-0.030	R0.250	✓		R-6	
E	0.625	+/-0.030	0.630	✓		Vern	
F	0.250	+/-0.010	0.254	✓		Micro	
G	0.950	+0.030/-0.010	0.960	✓		Vern	
H	0.25 x 45°	+/-0.030	0.230 x 45°	✓		Vern	
I	0.375	+/-0.010	0.380	✓		Vern	
J	12.750	+/-0.030	12.750	✓		M-Tape	
K	Ø0.260	+0.005/-0.000	Ø0.260	✓		Vern	
L	Ø0.93	+/-0.030	Ø0.928	✓		Vern	
M	0.30	+0.030/-0.000	0.306	✓		Vern	
N	4.250	+/-0.030	4.250	✓		Vern	
O	0.375	+/-0.030	0.385	✓		Vern	
P	2.000	+/-0.030	2.000	✓		Vern	
Q	4.250	+/-0.010	4.250	✓		Vern	
R	9.000	+/-0.010	9.000	✓		M-Tape	
S	15.750	+/-0.030	15.750	✓		Vern	

Measured by: <i>gml</i>	Audited by: <i>gml</i>	Prototype Approval:	N/A
Date: 05/06/02	Date: 05/06/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10005	KJ/RF	<i>[Signature]</i>

RELEASED

04.01.15

## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 18, 2005  
02:29 pm

Work Order No	: 0023076	Department Code:	
Project Name	: K10005	Burden Flags	: NNNNNNNN
Project For	: WK519	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *K10005	Invoice Number	:
Description	: Bearpaw kit 13" x 16"	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 5	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 04-18-05		
Est Finish Date	: 04-30-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00